

Work Order ID 67640

Tuesday, March 29, 2011 8:23:19 AM



Page 1

Item ID: D3212-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Window

Start Date: 3/28/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

11-03-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3212	Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut blankas per Dwg D3212

☐ Dwg Rev:

B

☐ Prog Rev:

B

☐

2-Deburr if necessary

H311-4-4

(6)

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS.CNC vertical machine #1

Machine as per Folio FA349 and Dwg D3212

cmr 11/04/11

6

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

cmr 11/04/11

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00

G.A 11/04/11

6

0



QC

Memo

0.00

Quality Control

140

Small Fab

0.00

0.00



Small Fab

Memo

1-Deburr if necessary ☐ 2-Install label as per Dwg D3212 ☐ 3- polish abrasion scratches if necessary.. ☐ 4-Wrap in plastic wrap after inspection

Small Fab

G.B 11/04/20 (6)

150

QC5- Inspect part completeness to step on W/O

0.00

0.00

S 11/04/10



QC

Memo

Quality Control

(46)

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Page 3

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Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location 210

0.00



Packaging

Memo

0.00

Packaging

11/4/28

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/25

11-09-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 8:23:25 AM

Page 1

Work Order ID: 67640

Parent Item: D3212-1

Parent Item Name: Floor Window



Start Date: 3/28/2011

Required Date: 4/1/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: A New Issue 05-11-09 JLM
 IPP Rev: B Water jet/ ecn798 06-05-08 EC
 IPP rev.C back on haas 07.04.09 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2728-1 		Manufactured	No			100	Each	0.0000	0	0			
Dart Logo label MACRLICS.125 		Purchased	No			140	sf	10.0000	0.9745	4.103158			
1/8" Polycast II Sheet													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT019				10					
				115338				10					
										115338			

WB 11-4-4

6

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DART AEROSPACE LTD		Work Order:	676410
Description: Floor Window		Part Number:	D3212-1
Inspection Dwg: D3212 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.734	+/-0.005	12.734	—		M-type ML-2	
6.367	+/-0.005	6.637	—		"	
0.625	+/-0.005	0.624	—		Vern ML-7	
Ø0.156	+0.005/-0.001	Ø.156	—		"	
R0.25	+/-0.030	R.250	—		Red-gage	
8.150	+/-0.005	8.150	—		M-type ML-2	
3.750	+/-0.005	3.750	—		"	
0.313	+/-0.010	0.313	—		Vern ML-7	
15.14	+/-0.030	15.150	—		M-type ML-2	
12.520	+/-0.005	12.520	—		"	
6.260	+/-0.005	6.260	—		"	
1.312	+/-0.005	1.315	—		Vern ML-7	
0.313	+/-0.010	0.310	—		"	
3.750	+/-0.005	3.750	—		"	
8.150	+/-0.005	8.150	—		M-type ML-2	
8.462	+/-0.005	8.462	—		"	
9.09	+/-0.030	9.100	—		"	

Measured by: <i>amf</i>	Audited by: <i>K.A</i>	Prototype Approval:	N/A
Date: 11/04/11	Date: 11/04/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	07.05.28	Dimensions updated per Dwg Rev. B	KJ/JLM	<i>[Signature]</i>

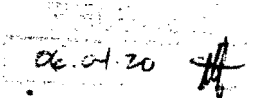
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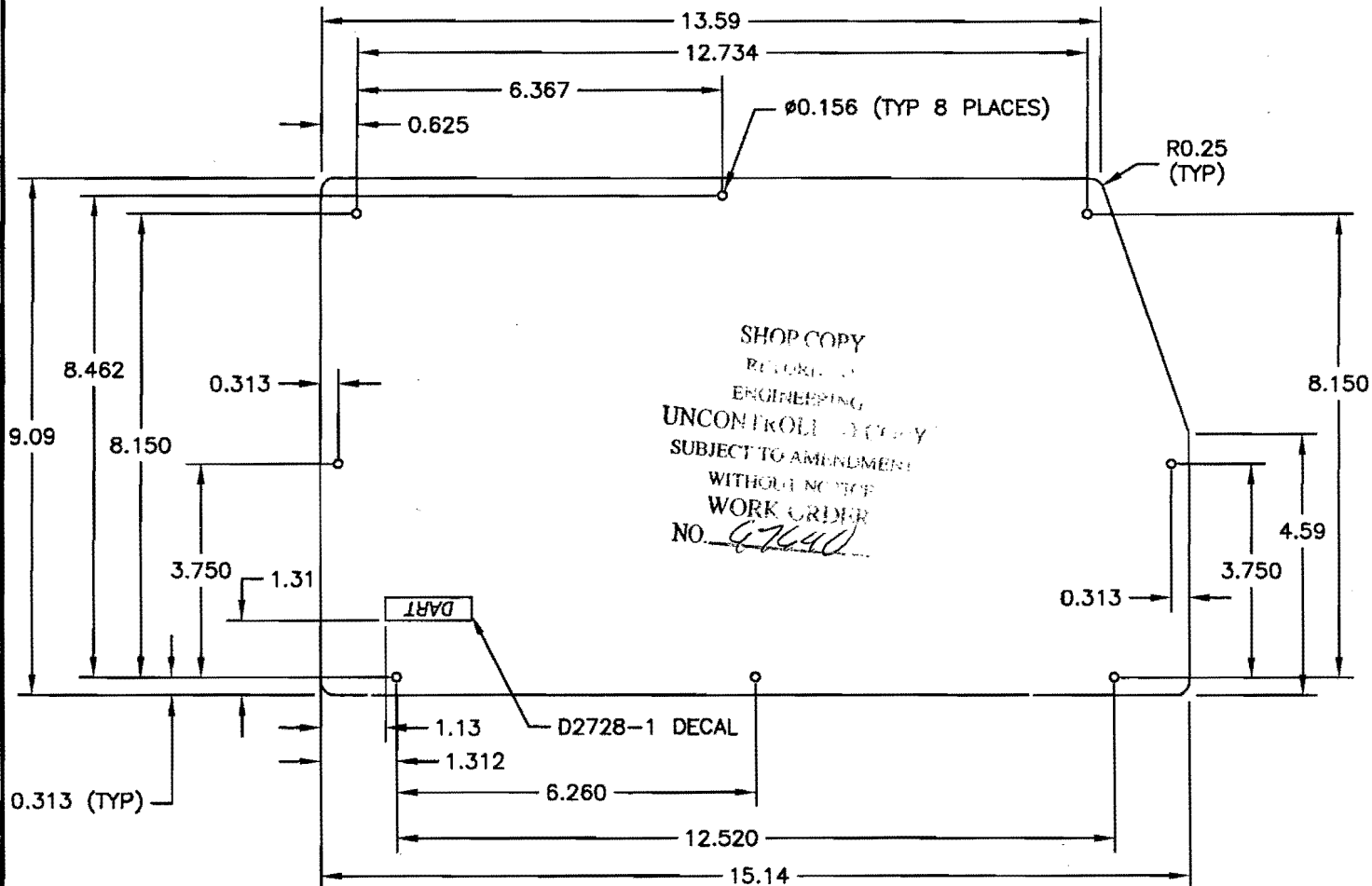
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- 1) CHECK DIMENSIONS WITH TEMPLATE D3212-1T1
- 2) DIMENSIONS ARE IN INCHES AND ARE FOR REFERENCE ONLY
- 3) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67640

DESIGN		DRAWN BY		DART AEROSPACE LTD	
CP		SSH		HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. B	
<i>[Signature]</i>	<i>[Signature]</i>	D3212		SHEET 1 OF 1	
DATE		TITLE		SCALE	
06.04.13		FLOOR WINDOW		1:3	
A	03.09.03	NEW ISSUE			
B	06.04.13	UPDATE MATERIAL PER NCR 029			

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